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D5445-042
Job Sheet 187744



Part No: D5445-042

Job Qty: 2 ea

Part Name: Longitudinal Beam Assembly, RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/13/18

Job Tracking No:

Due Date: 12/28/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: D5445 REV C SHEETS 2,5 IPP REV:A 17.01.10 NEW ISSUE DD VERF:JLM IPP REV:B 17.11.15 REVISE AS PER INTUITIVE INSTRUCTION DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		12/28/18	0.00	0.00	Start Up Skid tubes-1		MGR
100	CNC Bend Skid tubes	2 pcs		12/28/18	0.00	2.00	CNC Bend Skid tube		MGR
110	QC	2 pcs		12/28/18	0.00	0.00	QC2 5		MGR
120	Mill Conv	2 pcs		12/28/18	0.00	2.00	Conv Mill 1		MGR
130	QC	2 pcs		12/28/18	0.00	0.00	QC2		MGR
140	QC	2 pcs		12/28/18	0.00	0.00	QC8		MGR
150	HandFinish	2 pcs		12/28/18	0.00	1.00	HandFinish1		MGR
160	QC	2 pcs		12/28/18	0.00	0.00	QC7		MGR
170	Small Fab	2 pcs		12/28/18	0.00	2.00	Small Fab		MGR
180	QC	2 pcs		12/28/18	0.00	0.00	QC5		MGR
184	Skid tubes	2 pcs		12/28/18	0.00	1.00	Skid tubes-2		MGR
186	QC	2 pcs		12/28/18	0.00	0.00	QC5		MGR
190	Powdercoat	2 pcs		12/28/18	0.00	1.00	Powdercoat1		MGR
200	QC	2 pcs		12/28/18	0.00	0.00	QC3		MGR
210	HandFinish	2 pcs		12/28/18	0.00	1.00	HandFinish4		MGR
220	QC	2 pcs		12/28/18	0.00	0.00	QC5		MGR
230	Packaging	2 pcs		12/28/18	0.00	0.00	Packaging 3		MGR
240	QC21-SA	2 Ea		12/28/18	0.00	0.00	QC21		MGR

Part Op 100 - BEND/CUT AS PER DWG

Descriptions: 120 - MILL/DRILL AS PER DWG. -insure proper orientation -DEBURR

170 - INSTALL NUT PLATES AS PER DWG

184 - 1- Pick (4) D4720-1 space for each beams and chemical convert them. 2- Swage x-bolt spacers as per dwg. Trim off excess material as required. 3- After swaging, ream x-spacer hole if necessary to finish size. 4- Touch up alodine after swaging. 5-INSTALL END CAP

190 - ***MASK NUT PLATE HOLES*** START TIME: 10:30 OVEN TEMPERATURE: 320° FINISH TIME:

11:00 M138947

210 - SEAL END CAPS WITH SIKAFLEX AS PER NOTE 11

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6TR1.5X1.0W125	6061-T6 Rect Tube 1.5 X 1.0 X .125W	12 ft (6 ea)	90-Start up Operation	5108232
CR2672-3-(03)	Cherry Rivet	16 Ea (8 ea)	170-Small Fab	5191242
MS21059-4	Nut Plate	8 Ea (3 ea)	170-Small Fab	5065256

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor			
				QC / QA Coordinator			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread					
		Other/Details:					

MS21061L4
D4720-1
D5445-043
MS24694-S3

Nutplate
Spacer
End Cap Assembly
Screw

4 2 Ea (1 ea) 170-Small Fab
8 Ea (4 ea) 184-Skidtubes
4 Ea (2 ea) 184-Skidtubes
8 Ea (4 ea) 184-Skidtubes

50163257
5030687
13158775
5094431

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6TR1.5X1.0W125	12	24	0
170-Small Fab	CR2672-3-(03)	16	14	0
	MS21059-4	6	25	0
	MS21061L4	2	42	0
184-Skidtubes	D4720-1	8	121	0
	D5445-043	4	12	0
	MS24694-S3	8	107	0

Part Specifications

Specifications could not be found.

Plex 12/13/18 11:22 AM Dart.lajeunesse.marie

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AEROSPACE

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Contain:



Part: D5445-042

Job No: 187744

Serial No/Batch: S138572

Revision: C

Inspector:

Exp Date:

Instructions: Various STC's

Date: 12/18/18

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART AEROSPACE LTD		Work Order:	1877
Description: Longitudinal Beam Assy. RH		Part Number:	D5445-042
Inspection Dwg: Sema co P/N	Rev: C	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
62,8	± 0,12	62,812	✓		Tape	
0,60 (2 PL)	± 0,02	0,600	✓		Vernier S.V.O.S	
0,177 "	± 0,005 - 0,001	0,178	✓		"	
0,320 × 100°	+0,006 - 0,001	0,325	✓		"	
1,00 REF	± 0,03	0,998	✓		"	
1,50 REF	"	1,496	✓		"	
0,13 REF	"	0,128	✓		"	
54,63	"	54,625	✓		"	
1,50	"	1,500	✓		"	
1,000	± 0,010	1,000	✓		"	
4,97	± 0,03	4,970	✓		"	
0,500	± 0,010	0,500	✓		"	
1,200	"	1,200	✓		"	
0,850	"	0,850	✓		"	
0,300	"	0,300	✓		"	
0,600	"	0,600	✓		"	
0,375 (4 PL)	+0,006 - 0,001	0,377	✓		"	
0,266	+ " - "	0,267	✓		"	
0,098	+ 0,004 - 0,001	0,098	✓		"	
0,179 × 100°	+0,005 - 0,001	0,182	✓		"	
0,250	± 0,010	0,250	✓		"	
0,500	"	0,500	✓		"	
1,000	"	1,000	✓		"	
0,312	"	0,312	✓		"	
2,05	+ 0,12 - 0,05	2,090	✓		Tape	
13,	± 2	13"	✓		Tape	

Measured by:	N	Checked by:	mf	QC Inspector:	
Date:	19/1/23	Date:	19/01/24	Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	